

# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D206-642 REV. P  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV.5

REF. FAA STC: SA00475SE

REF. CANADIAN STC: SH98-4

REF. EASA STC: EASA.IM.R.S.01320

## **1.0 PURPOSE:**

The purpose of this Dart Service Instruction is to provide customers with a kit to upgrade the Nutplate Assembly that retains the Tow Ring on their D206-642-XXX Skidtubes .

This kit also contains a bushing for modifying the Tow Ring itself to prevent the bolt from backing off.




Each kit contains materials for modifying (1) D206-642-XXX Skidtube.

## **2.0 PARTS LIST:**

QTY -011	PART NUMBER	DESCRIPTION
X	DSI9653-011	TOW RING MOD KIT
1	D4825-041	NUT PLATE ASSY
1	D4859-1	BUSHING
1	AN4C5A	BOLT
1	NAS1149C0463R	WASHER (OR AN960C10L)
2	CCR264SS3-3	CSK BLIND RIVET (STAINLESS STEEL)
12	CR3522-4-03	CSK BLIND RIVET (MONEL)




## **3.0 WEIGHT AND BALANCE:**

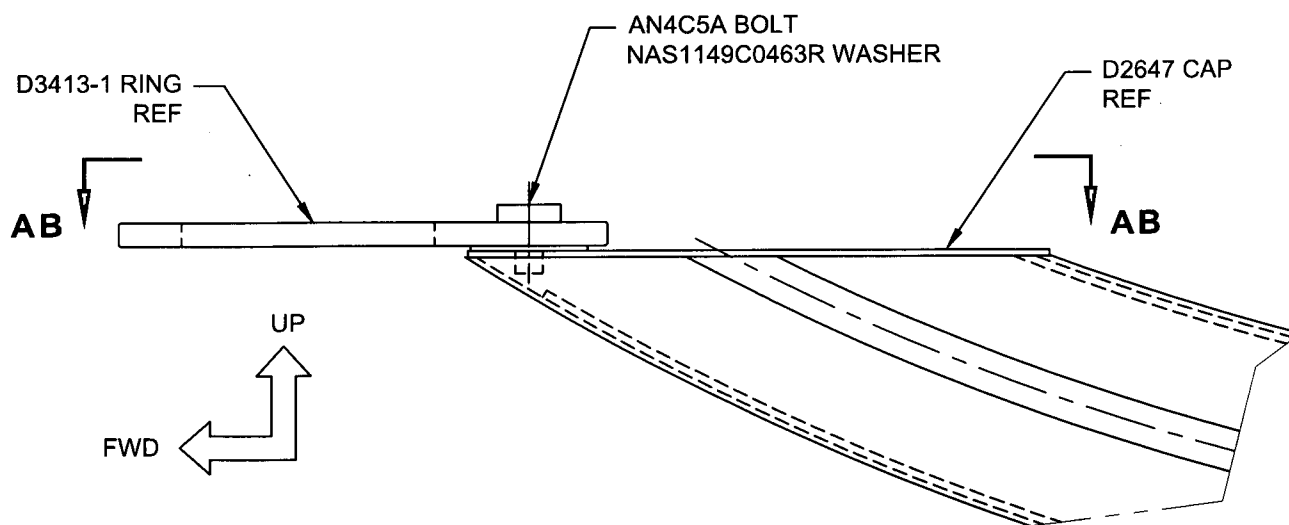
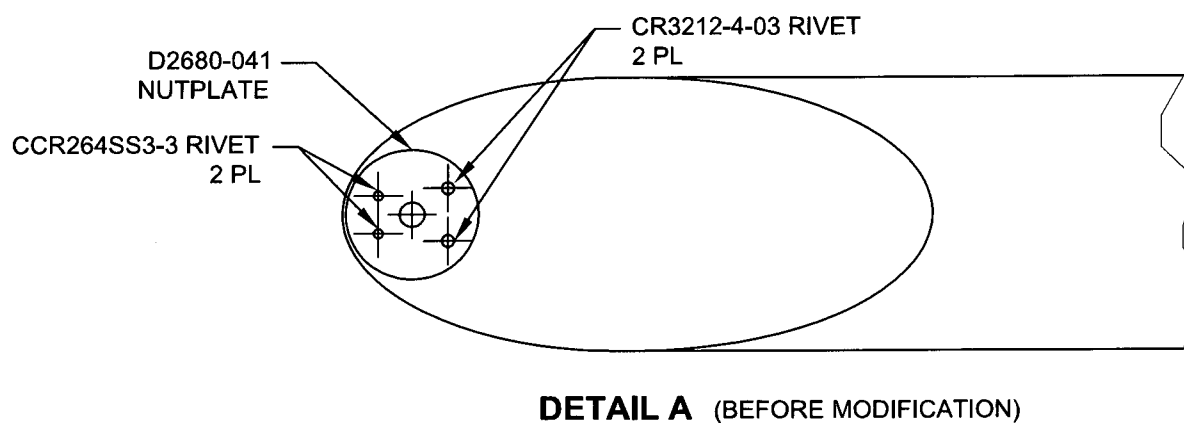
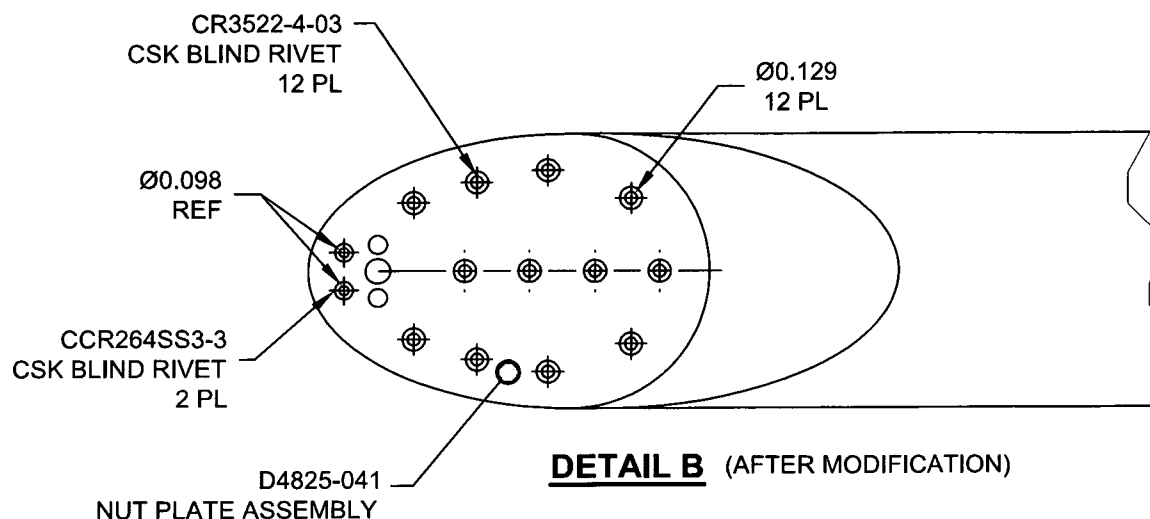
There is a negligible weight change associated with this modification.

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REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9653	SHEET 1 OF 4
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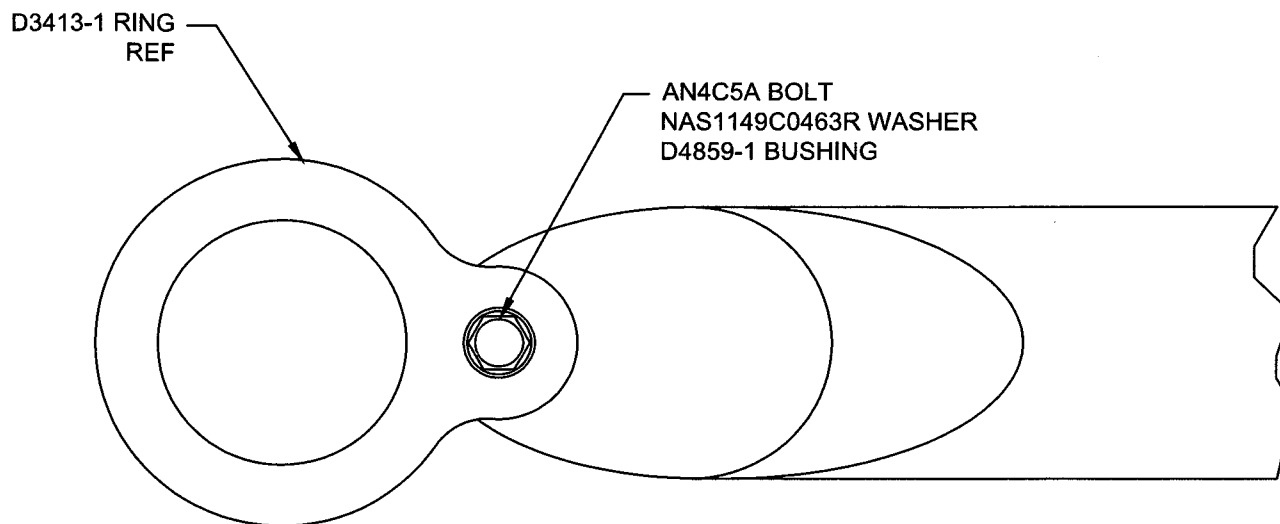
#### 4.0 PROCEDURE:

- 4.1 On the forward end of the D206-642-XXX Skidtube locate, remove, and retain the D3413-1 ring by removing the (1) AN4C5A bolt and (1) NAS1149C0463R washer as shown in Figure 1 of this Service Instruction. Discard the hardware (replacement hardware is included with this kit).
- 4.2 Remove and discard the D2680-041 Nutplate by drilling out the (2) CCR264SS-3 AND (2) CR3212-4-03 rivets as shown in Detail A of this Service Instruction.
- 4.3 Remove all of the anti skid finish from the from the D2647 cap.
- 4.4 Locate the D4825-041 Nut Plate Assembly on the the Skidtube. Transfer drill (12) Ø0.129 holes thru the D2647 Cap as shown in Detail B of this Service Instruction.
- 4.5 Deburr all holes. Touch up finish with chemical film material (Alodine 1200 or 1201) per MIL-C-5541, one coat of MIL-P-85582 or MIL-P-23377 primer and 2-3 coats MIL-C-83285 polyurethane paint to match finish.
- 4.6 Coat the mating surface of the D4825-041 Nut Plate Assembly with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 sealant, ensure the threads on the nutplate are not plugged with sealant.
- 4.7 Relocate the D4825-041 Nut Plate Assembly onto the Skidtube and install (12) CR3522-4-03 blind rivets and (2) CCR264SS3-3 blind rivets as shown in Detail B of this Service Instruction.
- 4.8 At the discretion of the installer, reapply black anti skid paint per MIL-W-5044 Type 2. Ensure that the nutplate threads in the D4825-041 are masked prior to applying black anti skid paint.
- 4.9 Modify the D3413-1 Ring as shown in Figure 2 of this Service Instruction. Touch up finish using one coat of MIL-P-85582 or MIL-P-23377 primer and 2-3 coats MIL-C-83285 polyurethane paint to match finish.
- 4.10 Reinstall the D3413-1 Ring using (1) D4859-1 Bushing, (1) AN4C5A Bolt AND (1) NAS1149C0463R Washer per Figure 3 of this Service Instruction.

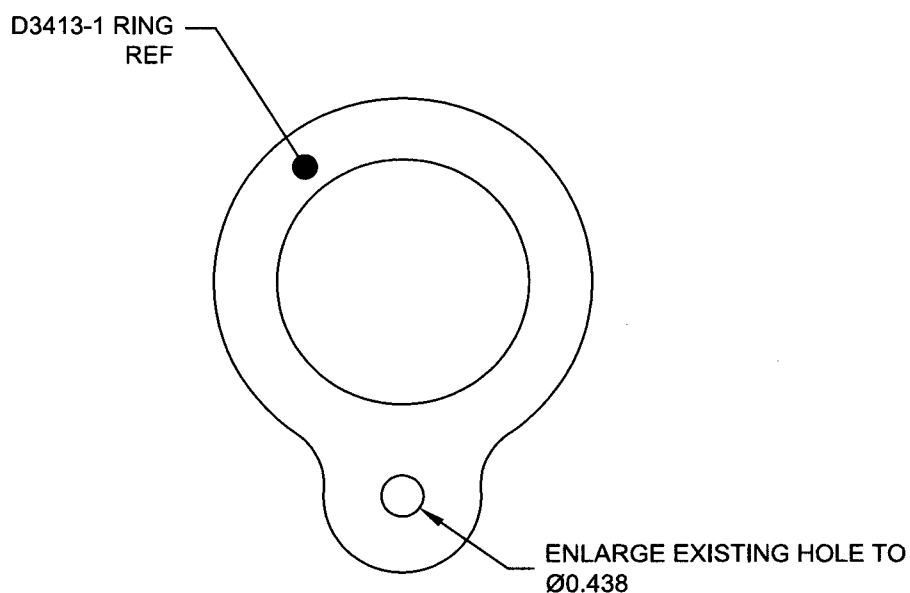
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**FIGURE 3**



**FIGURE 2**

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